

6061 R 0.750"

Work Order ID **77047**

November-25-11 8:29:57 AM

77047

Item ID: D2022-101 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacer
Start Date: 25/11/2011 Start Qty: 60.00 ***60*** Cust Item ID:
Required Date: 09/12/2011 Req'd Qty: 60.00 ***60*** Customer:
Reference:

Approvals: Process Plan: M.L.J Date: 11/11/25 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2022	Rev. 97.01.14	<u>11.11.25</u>							
100		0.00							
100									
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	Note: 257" dia drill 1-Turn as per folio FA206 & dwg FOLIO REV: <u>N/A</u> DWG REV: <u>N/A</u> 2-Deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

60 0 11/12/28
60 0 11/12/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77047

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Page 2

November-25-11 8:29:57 AM

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 Required Date: 09/12/2011 Req'd Qty: 60.00 ***60*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00		BA 11/12/28		60	0		
Quality Control									
130	Identify as per dwg & Stock Location: <u>Sot</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

11/12/29 (60)

CK 12/01/02

11/12-29
60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-25-11 8:30:00 AM

Page 1

Work Order ID: 77047

77047

Parent Item: D2022-101

D2022-101

Parent Item Name: Spacer

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP D02.03.07 Now made in house NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6R0.750		Purchased	No			100	f	46.1140	0.03	1.8			
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M6061T6R0 750

6061-T6 Round Bar .750"

**

1.667

SL 11/12/28

Location

Loc Qty

Loc Code

MAT013

46.114

112442

0.796

117481

1.969

118106

1.338

119231

18.011

119613

24

1.667

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

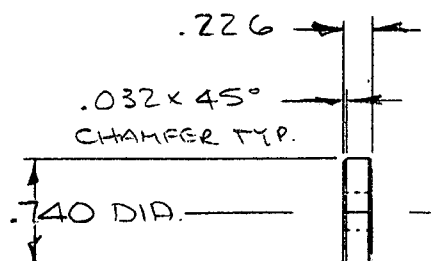
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
970119 BW



DRILL 'F' (.257) DIA. IN -101
DRILL P (.323) DIA IN -103

D2022-101
D2022-103

MAT'L: ALUMINUM 6061-T6 (QQ-A-225/8)



D2022

D2022-103		SPACER 5/16 ALUM. 6061-T6		QQ-A-250/8	
D2022-101		SPACER 1/4 ALUM. 6061-T6		QQ-A-250/8	
PART NO.		ITEM		DESCRIPTION	
MATERIAL		SPEC./VENDOR			
REVISION		DRAWN		APPROVED	
DESCRIPTION OF CHANGE		REQUIREMENTS - UNLESS OTHERWISE SPECIFIED		RIVET CODE SHALL BE PER NAS 523	
1. DIMENSIONS ARE IN INCHES		1. TOLERANCES - .001 & .020		BASIC CODE	
2. SURFACE ROUGHNESS 125		2. ANGLES 30° & 45°		DASH NO. OF RIVETS	
3. REMOVE SHARP EDGES .015 MAX		3. PARALLELISM .005		DASH NO. OF SPOTWELDS	
4. THREADS PER NAS - S-7742		4. ECCENTRICITY .004 MAX		BASIC CODES	
5. HOLES PER AND 10587		5. SYMMETRY ABOUT ALL MTC CENTRE LINES .005		BASIC CODES	
REPORT ALL DISCREPANCIES - DO NOT SCALE					
CONTRACT NO.		DATE		DART AERO ACCESSORIES INC	
DESIGN		CLIENT		TITLE	
CHECKED		CODE		D2022	
CLIENT		SCALE 1:1		SHT 1 OF 1	

